

SCRAP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 174834

**Part No:** D350-636-011**Job Qty:** 1 ea**Part Name:** Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 3/22/18**Job Tracking No:****Due Date:** 4/17/18**Created By:** Michelle Gagnon-Donovan**Type:** SOLD**Description:**

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:**Bill of Materials**

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Container No: S056708**Part:** D350-636-011**Job No:** 174834**Serial No/Batch:** S056708**Revision:****Inspector:**

Date: 03/29/18

SCRAP

6210

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/16/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		4/16/18	0.00	4.55	Skidtubes-4		
120	QC	1 pcs		4/16/18	0.00	0.00	QC10		
130	QC	1 pcs		4/16/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		4/16/18	0.00	0.93	HandFinish1		
150	QC	1 pcs		4/16/18	0.00	0.00	QC7-2		
160	Skidtubes	1 pcs		4/16/18	0.00	4.55	Skidtubes-4		
170	QC	1 pcs		4/16/18	0.00	0.00	QC10		
180	QC	1 pcs		4/16/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		4/16/18	0.00	0.93	HandFinish2		
200	SprayPaint	1 pcs		4/16/18	0.00	0.91	Spray Paint		
205	Outsource	1 pcs		4/16/18			ATE003-VC		
210	QC	1 pcs		4/16/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		4/17/18	0.00	0.93	HandFinish4		
240	QC	1 pcs		4/17/18	0.00	0.00	QC5		
250	Packaging	1 pcs		4/17/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		4/17/18	0.00	0.00	QC4		
265	DC	1 pcs		4/17/18	0.00	0.00	DC		
270	Packaging	1 pcs		4/17/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		4/17/18	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: _____ 8-Grind welds flush as per Dwg D2750

160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: _____ exp. date: _____ ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: _____ 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: _____ EXP DATE: _____ 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5- Coat all exposed fasteners with "LPS Procyon" batch: _____

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011 Location : FG072

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5043969
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	11	0
	D2744	1	15	0
160-Skidtubes	D2739	1	25	0
	D2743	8	201	0
	D3490-1	4	64	0
	D3490-3	4	47	0
230-HandFinish	ALS4-1032-225	38	1,149	0
	AN3C5A	34	191	0
	AN3C6A	4	330	0
	AN6C44A	4	407	0
	AN8C35A	1	63	0
	D2745	8	225	0
	D3488-041	1	9	0
	D3492-1	8	211	0
	D3492-3	8	144	0
	D3535-25	1	20	0
	D3536-25	1	34	0
	D3537-1	3	153	0
	D3631-1	8	59	0
	D3791-1	1	16	0
	D3793-1	1	20	0
	D3793-3	1	28	0
	D3794-1	1	16	0
	D3794-3	1	44	0
	MS21043-6	4	182	0
	MS21083C8	1	169	0
	NAS1149C0332R	38	4,898	0
	NAS1149C0832R	1	88	0
	NAS1515H3L	4	255	0
	NAS1611-010	8	389	0
	NAS1611-013	8	285	0
250-Packaging	AN8C21A	2	141	0
	D2741	1	67	0
	D3493-1	2	60	0
	D3532-1	2	38	0
	MS21083C8	2	169	0
	NAS1149D0863J	2	147	0

Part Specifications

Specifications could not be found.

Plex 3/22/18 9:20 AM Dart.Gagnon.Michelle

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 174834
MAR 21 2010

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2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3532-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

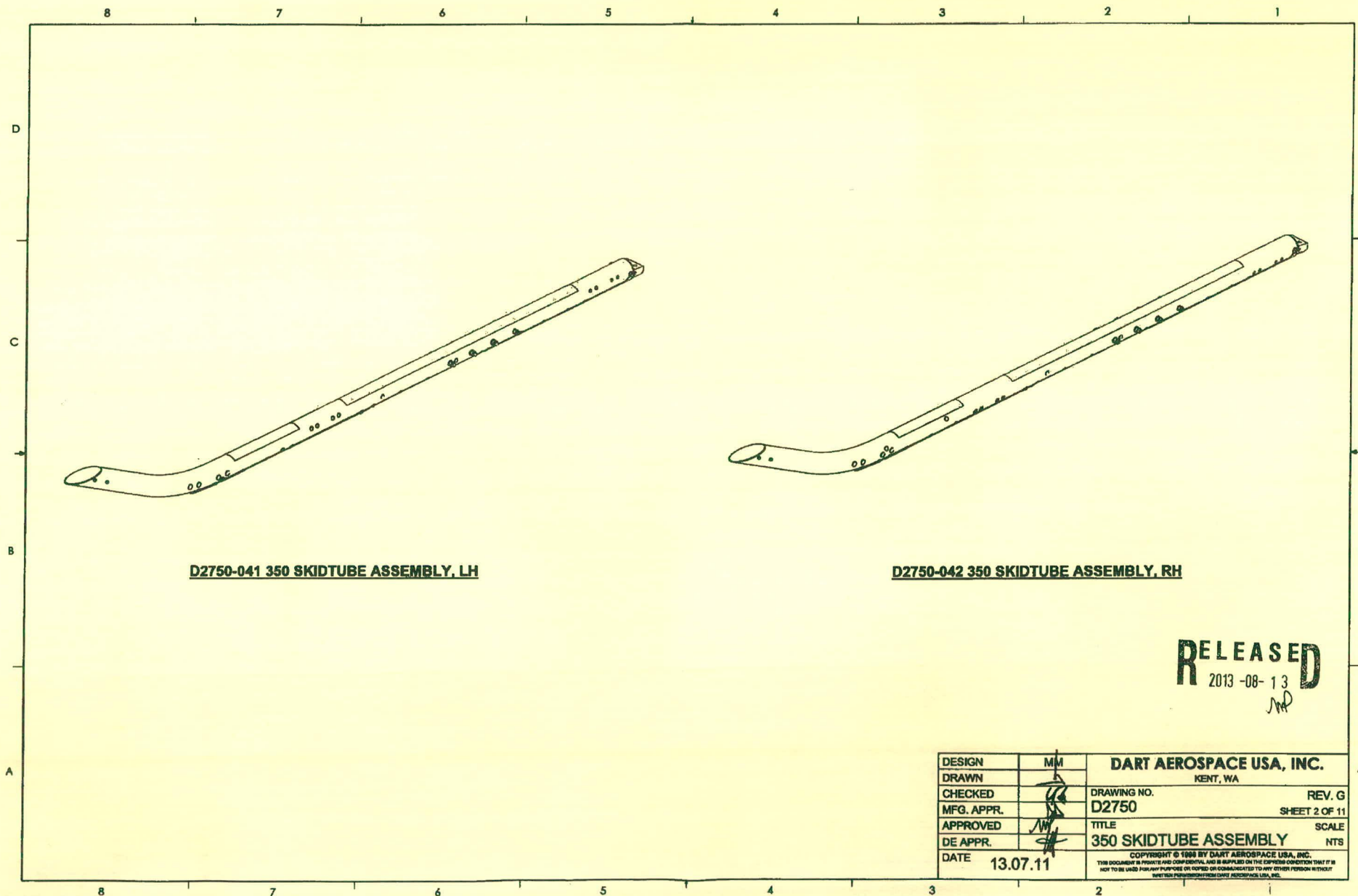
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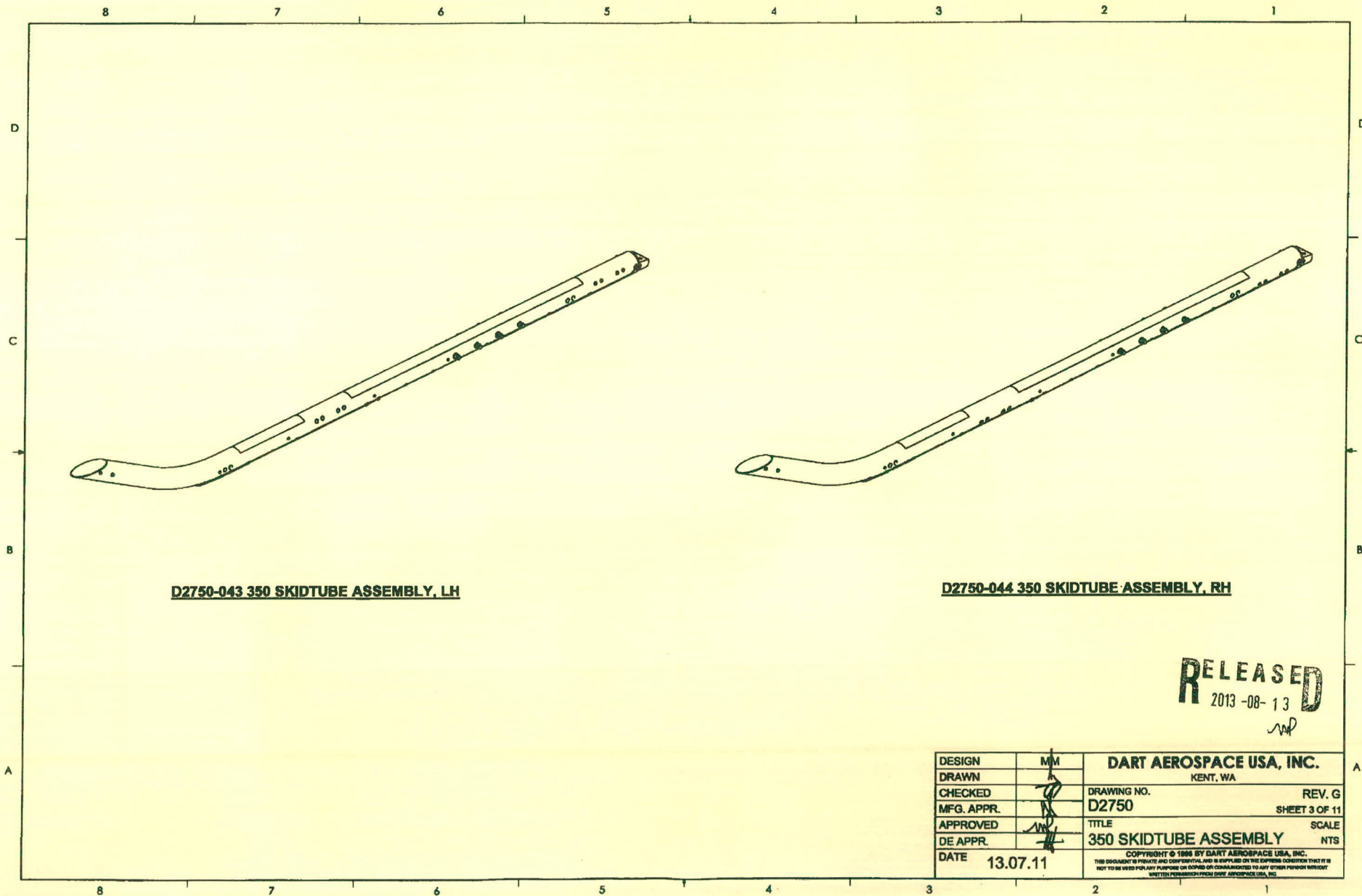
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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
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DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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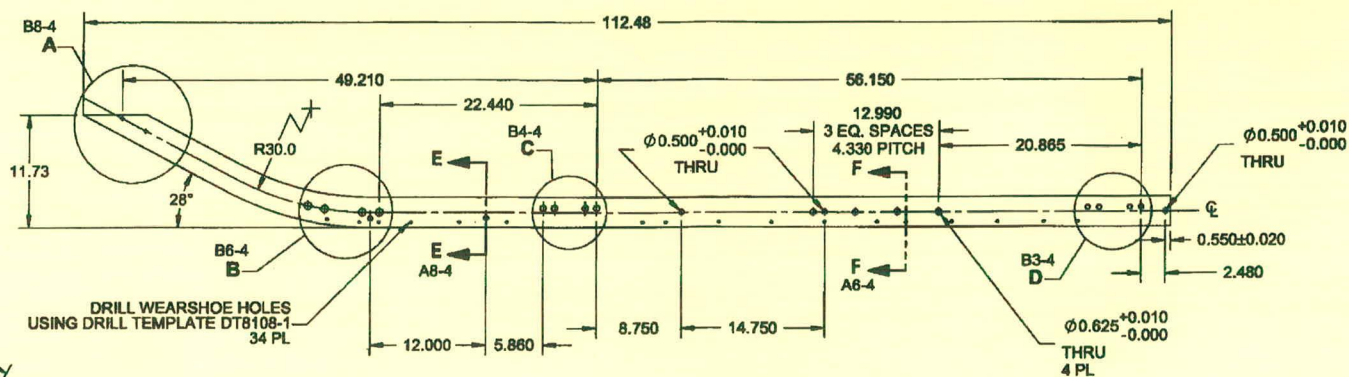


D2750-043 350 SKIDTUBE ASSEMBLY, LH

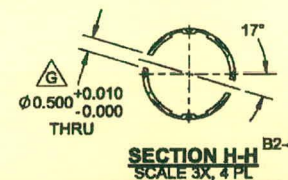
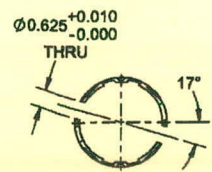
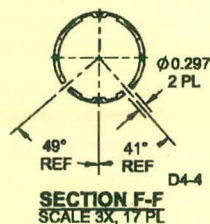
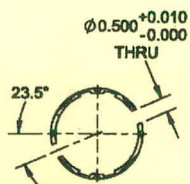
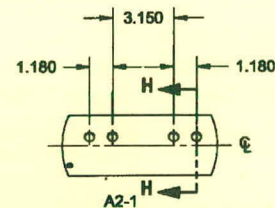
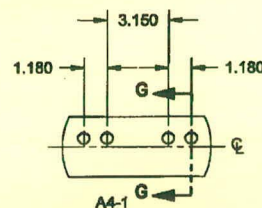
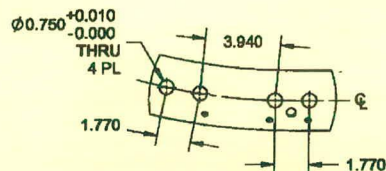
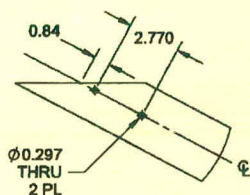
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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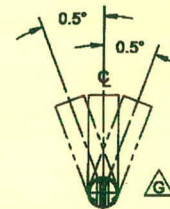
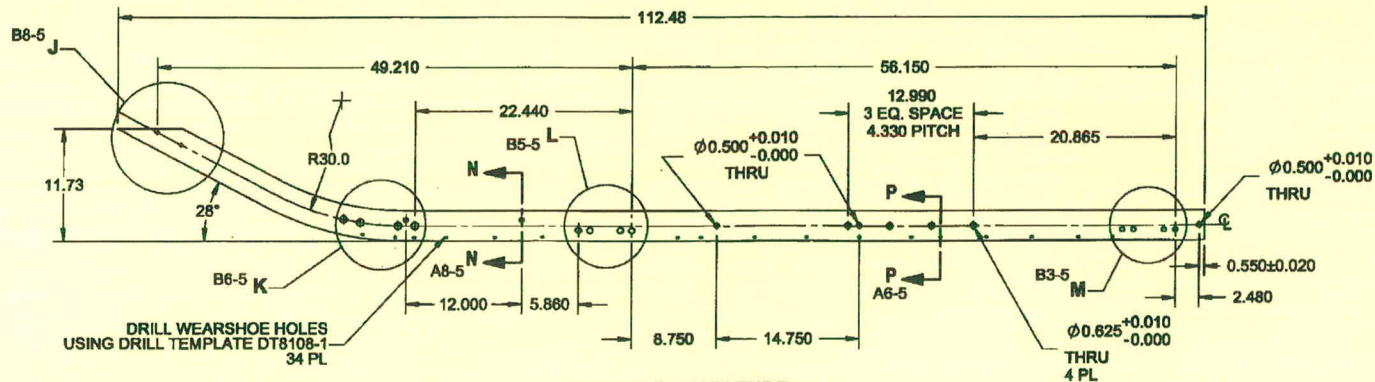
D2750-1 LH SKIDTUBE



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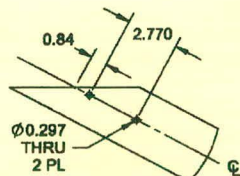
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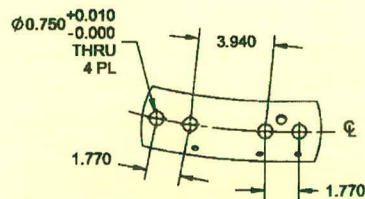
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

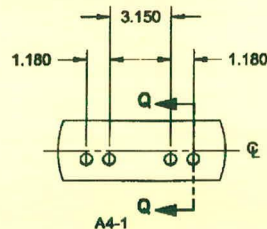
D2750-2 RH SKIDTUBE



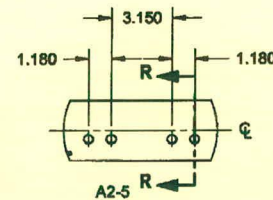
DETAIL J
SCALE 2X



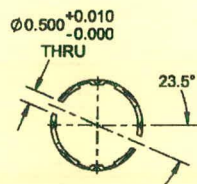
DETAIL K
SCALE 2X



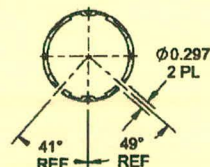
DETAIL L
SCALE 2X



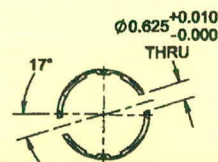
DETAIL M
SCALE 2X



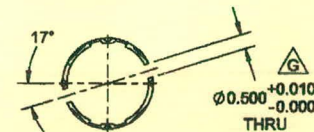
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

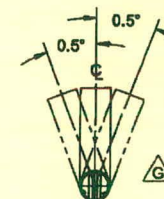
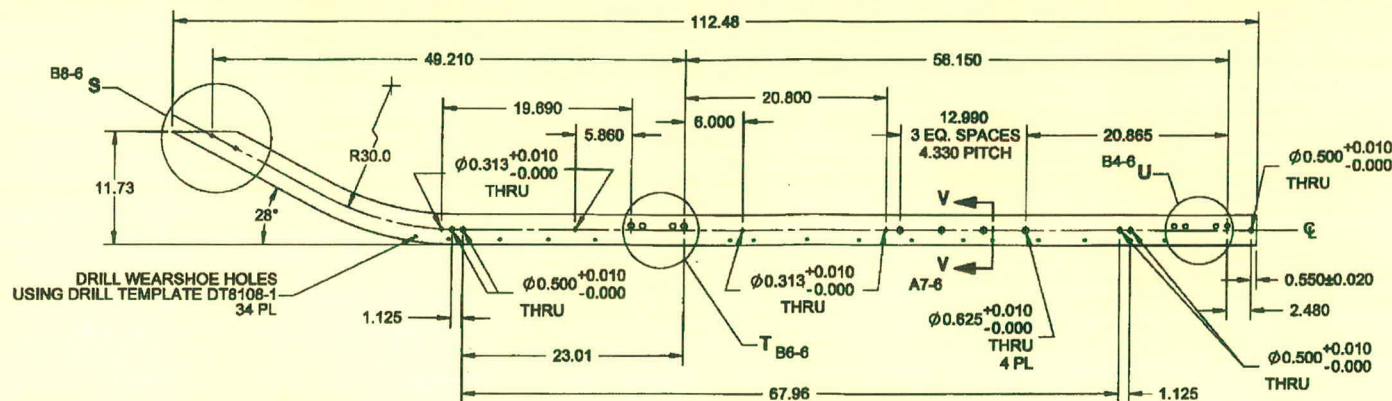
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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 6 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
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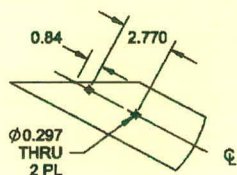
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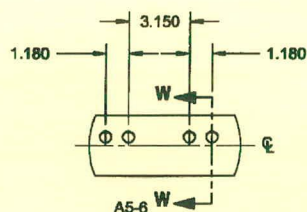


OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

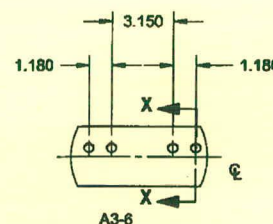
D2750-3 LH SKIDTUBE



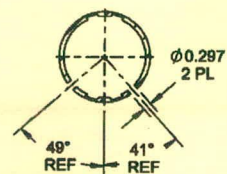
DETAIL S
SCALE 2X
D8-6



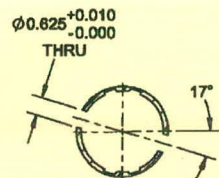
DETAIL T
SCALE 2X
C5-6



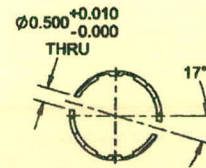
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



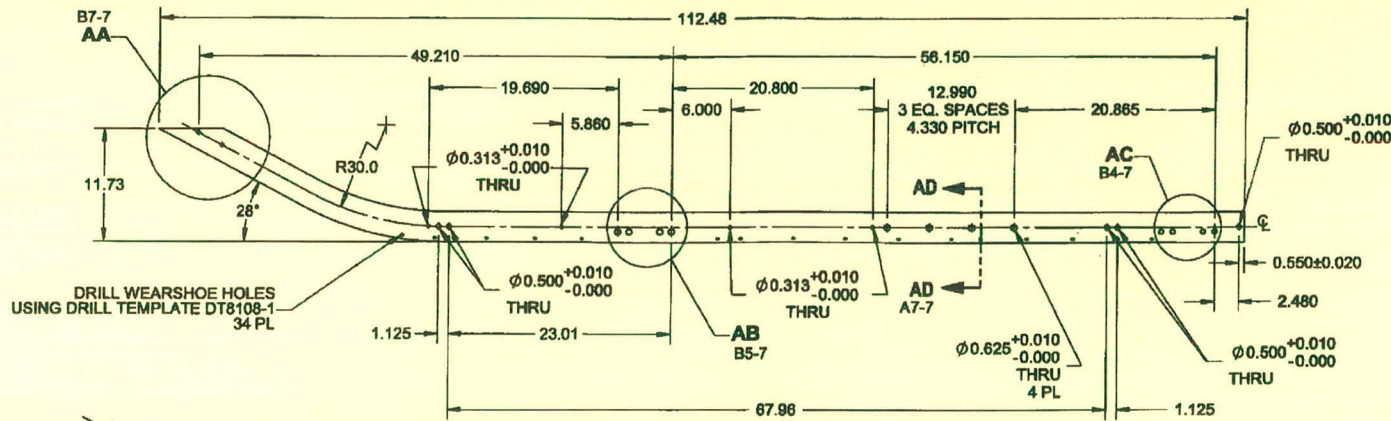
SECTION X-X
SCALE 3X, 4 PL
B4-6

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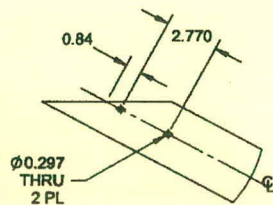
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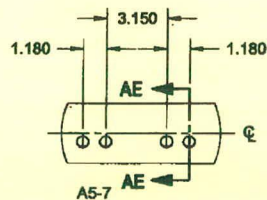
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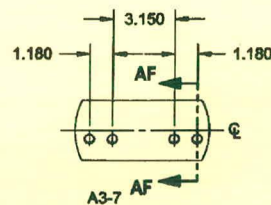
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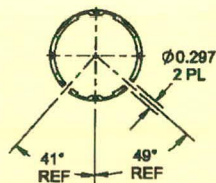
DETAIL AA
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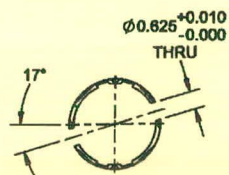
DETAIL AB
SCALE 2X



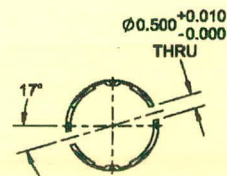
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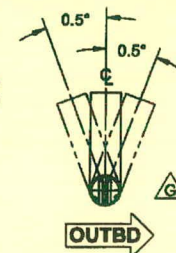
SECTION AD-AD
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SECTION AE-AE
SCALE 3X, 4 PL



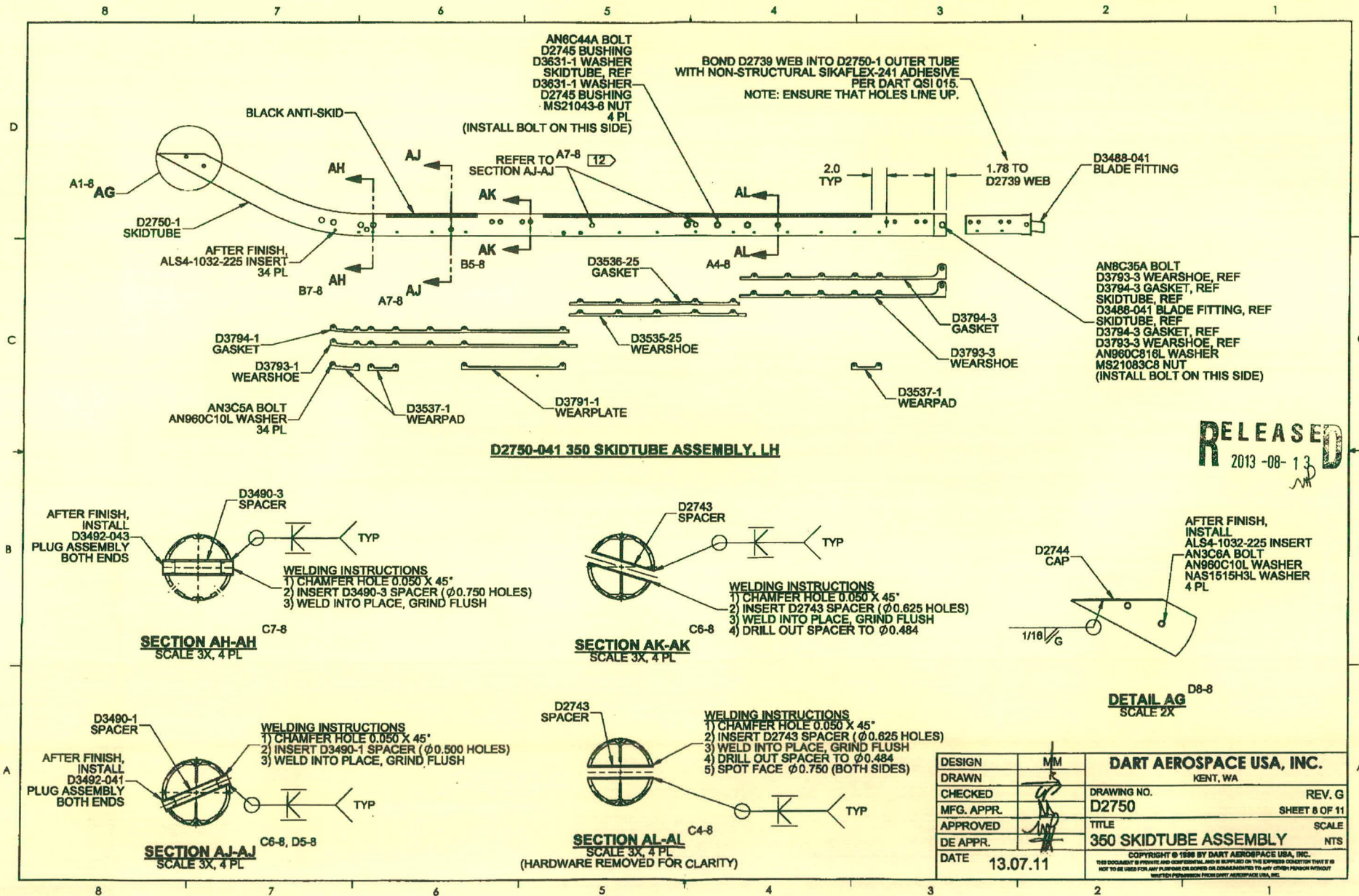
SECTION AF-AF
SCALE 3X, 4 PL



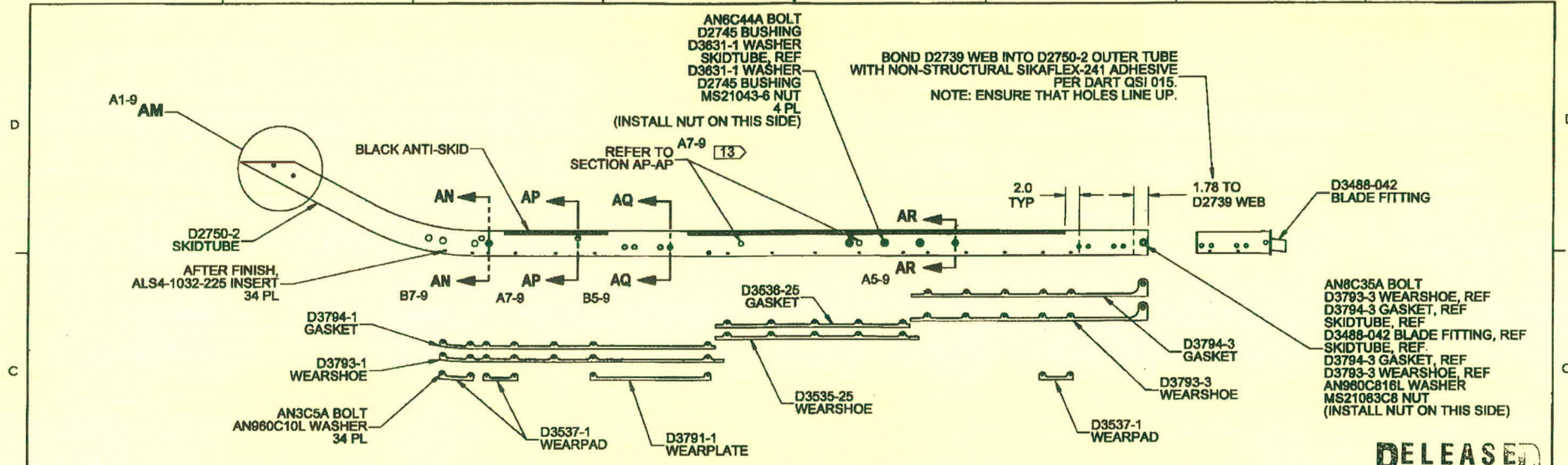
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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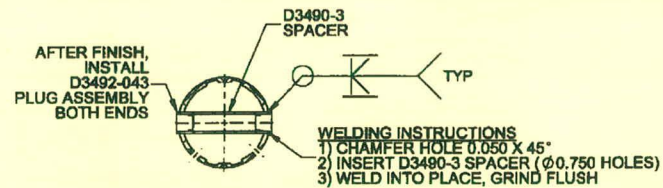


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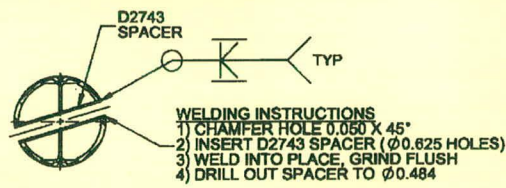


D2750-042 350 SKIDTUBE ASSEMBLY, RH

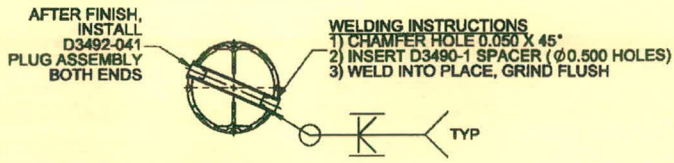
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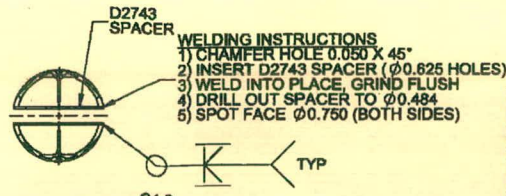
SECTION AN-AP
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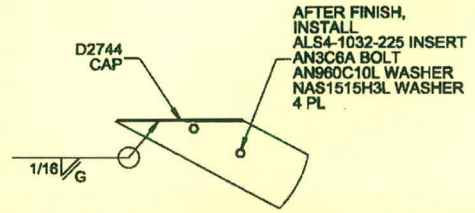
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

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8 7 6 5 4 3 2 1

